

Date: Wednesday, 04/02/2009 12:40:04 PM
 User: Chantal Lavoie

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	STEP EXTRUSION
Job Number	45494			
Estimate Number	10058			
P.O. Number	:		Part Number	D2622120C
This Issue	04/02/2009	S.O. No. :	Drawing Number	D2622 REV C1
Prsht Rev.	NC		Project Number	N/A
First Issue	11	Type : PURCHASED PARTS	Drawing Revision	C1
Previous Run	44064		Material	:
Written By	:		Due Date	23/02/2009
Checked & Approved By	C 809/02/04		Qty:	120
Comment	Est. A: 02.11.12	New Issue KJ/RF	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING	
	Issue P/O: 8134	C 809/02/04
	a) Extrude as per Dwg D2622 Rev. C	
	b) Material: 6061-T6 (QQ-A-200/8)	
	c) Minimum yield tensile strength = 35 ksi	
	d) Minimum ultimate tensile strength = 38 ksi	
	e) Minimum elongation = 8%	
	f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A	
	h) To be packed per DSK 066	
	i) Pull test to ASTM standard B221 required.	
	j) Material certification is required	
2.0	D2622120CP	Extrusion
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 120.0000 Each(s)	
	Extrusion	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Receive & Inspect For Transit Damage	
	Ensure material certification is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
	Inspect dimension per Dwg D2622	
	Check Pull test per Dwg D2622 for compliance page attached	
	Check hardness with Webster tester	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 04/02/2009 12:40:04 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 45494

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

1 HALL # 008 → 97 HALL # 007 → 26 = (123)

09/02/18 Hn

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/20 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

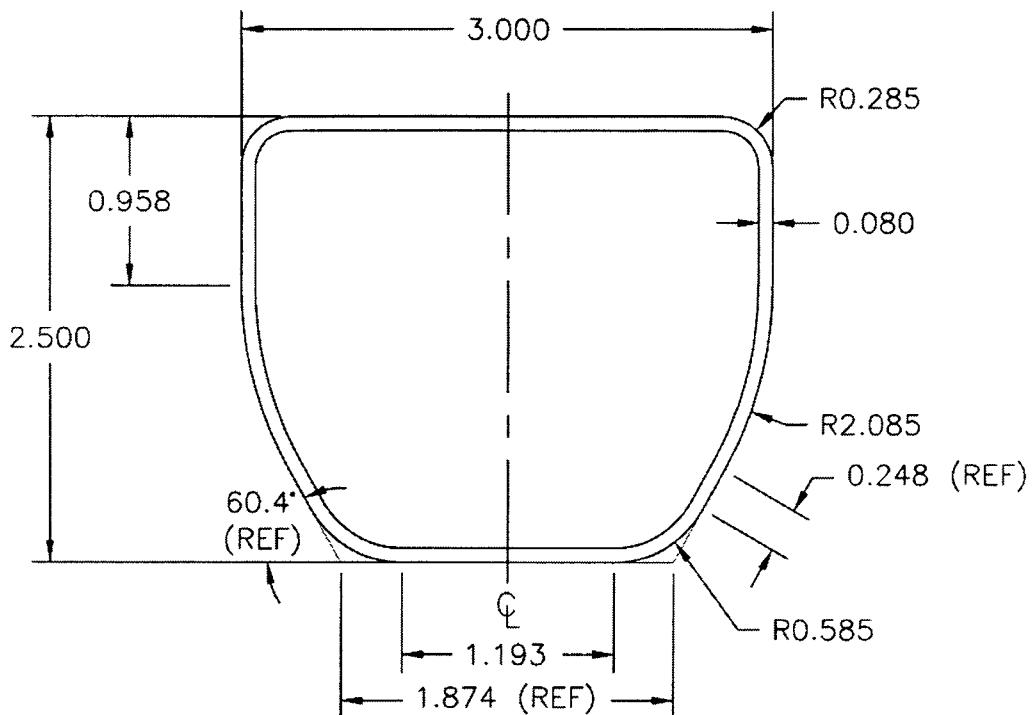
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY <i>SP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>W</i>	APPROVED <i>SP</i>	DRAWING NO. D2622	REV. C	SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1	
A	96.11.29	NEW ISSUE		
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI		
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.		
C1	<i>SP</i> 02.10.04	ADD 'REV. A' TO DIE NUMBER		



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES
(EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A 
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

CD 09/02/04
W10: 45494

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ACCT# 00046024

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN
PHONE 613-632-5200	PHONE 613-632-5200

CUSTOMER ID 46024	ORDER DATE 02/04/09	CUSTOMER PO NUMBER 8136
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INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HILL ON L4C 4Y9

TERMS / FREIGHT
O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

SHIPPING MANIFEST
MANIFEST DATE
02-13-09
MANIFEST NUMBER
654755
SALES ORDER NUMBER
43350

CREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

FIELD SALES REP
Kutter A
450-435-6551

CUST SERVICE REP
Burton D
905-427-2227

BILL OF LADING NUMBER
08388777

LOCATION RIH	TRAILER NUMBER 57393	SALESMAN 59358	JOB	
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT:	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER DAA-897123-1 D2622	ALLOY & TEMPER		FINISH DESCRIPTION		THIS SHIPMENT			UNIT	QUANTITY DUE		
					LENGTH		CUTTING TOLERANCE	FABRICATION DESCRIPTION		NBR OF PKGS	GROSS POUNDS	NET QUANTITY			
								SHIPPING TOLERANCE							
01	121	KG M PC	0 0 0	DAA-897123-1 D2622	6061 /T6 120" +3/16 " -0 "			MILL CERTIFICATE OF COMP (+015-015,0139-0102)		3	531	505 374.91 123	KG M PC	42 P 39 P 42 P <i>23mgs</i>	

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

3	531	505 374.91 123	KG M PC
TOTALS			

CERTIFICATE OF COMPLIANCE
SIGNATURE ALUMINUM CANADA

 500 EDWARD AVENUE
 RICHMOND HILL, ON L4C 4Y9

Certificate Date	Cert. No.	Sales Order	Page
02/13/09	187328	43350	1
20090113	B/L No.	Lot	Date
8136	08388777	43350010	2/13/09

Customer	43350010	Ship To	43350010
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	

Item No.	Part No.	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	531 KGS		
Net Wt.	505 KG	123 PC	375 M
Specification	AMS-QQ-A-200/8 & ASTM B221-08		
	<i>[Signature]</i>		

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	326.9 / 47.4	250.4 / 36.3	10.4	.0	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.27	.23	.07	.88	.05	.006	.05	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc